DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-022717
Date Inspected: 10-Apr-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 1900
OSM Departure Time: 700
Location: Shanghai, China

CWI Name:	See below			**CWI Present:**	☑ Yes	☐ No	
Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☐ Yes	☑ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Approved WPS:**	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: OBG

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for random observations relative to the work being performed.

Bay 14
This QA Inspector observed the following work in progress for Bay 14.
ZPMC was using the Shielded Metal Arc Welding (SMAW) process.
ZPMC QC is identified as Wong Xiang Pin, CWI Wang Jun.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

Components; OBG 14 W
PCMK: SEG3020U
Weld No: 591
Welder: 067572, 066002, 067609, 067904
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 14 W
PCMK: SEG3020BB
Weld No: 079
Welder: 045246, 045196
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 14 W
PCMK: SEG3020BB
Weld No: 047
Welder: 069841, 066261
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 14 W
PCMK: SEG3020AC
Weld No: 031
Welder: 067611
Weld Repair No. B-CWR20412
WPS-345-SMAW-2G(2F)-FCM-Repair-1

Components; OBG 14 W
PCMK: SEG3020X
Weld No: 004
Welder: 037779, 067829
WPS-B-P-2212-TC-U4b-FCM-1

Components; OBG 14 W (see photo below)
PCMK: DP3172-001
Weld No: Fit Up
Welder: 066398
WPS-B-P-2214

This QA Inspector observed the following work in progress for Bay 14.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Wong Xiang Pin, CWI Wang Jun.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

Components; OBG Traveler Rails
PCMK: TR3008TR1-001
Weld No: 002,003
Welder: 066695
WPS-B-T-2232-ESAB

Components; OBG Traveler Rails
PCMK: TR3008TR3-001
Weld No: 010,011
Welder: 066734
WPS-B-T-2232-ESAB

Components; OBG Traveler Rails
PCMK: TR3021TR2-001
Weld No: 004
Welder: 201215
WPS-B-T-2232-ESAB

Components; OBG Traveler Rails
PCMK: TR3021TR2-001
Weld No: 011
Welder: 058245
WPS-B-T-2232-ESAB

Components; OBG 14W
PCMK: SEG3020*
Weld No: 012
Welder: 045143
WPS-B-T-2232-ESAB

Components; OBG 14W
PCMK: SEG3020*
Weld No: 016
Welder: 201583
WPS-B-T-2232-ESAB

Components; OBG 14W
PCMK: SEG3020S
Weld No: 054
Welder: 062708
WPS-B-T-2233-ESAB

Components; OBG 14W
PCMK: SEG3020T
Weld No: 319,321
Welder: 048433
WPS-B-T-2232-ESAB

Components; OBG 14W
PCMK: SEG3020T
Weld No: 299
Welder: 2038713
WPS-B-T-2233-ESAB

Components; OBG 14W
PCMK: SEG3020G

Weld No: 006
Welder: 067876
WPS-B-T-2232-ESAB

Components; OBG 14W
PCMK: SEG3020J
Weld No: 018
Welder: 066673
WPS-B-T-2233-ESAB

Components; OBG 14W
PCMK: SEG3020AH
Weld No: 014
Welder: 066614
WPS-B-T-2232-ESAB

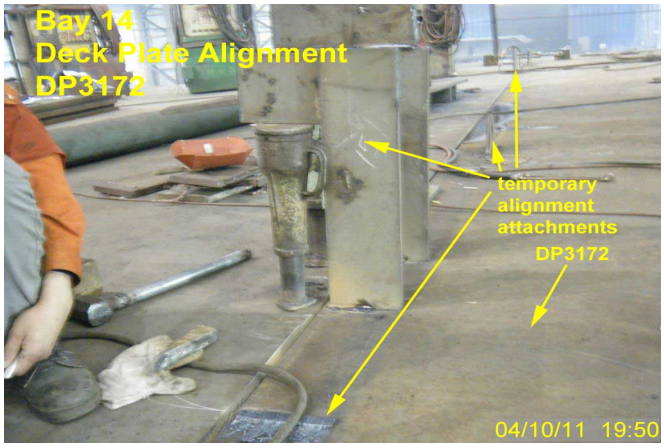
Heat straightening of PCMK TR3002TR1-001-002,004,006,007,008,010,011, under approved Heat Straightening procedure, HSR1 (B)-10279. The in process temperature was observed as 350°C. The ZPMC QC was identified as Wong Xiang Pin. The approved HSR procedure stated that a maximum temperature of 650°C with 1-3 numbers of applications was allowed. The distortion that was previously measured and recorded on the HSR was Maximum 6mm.

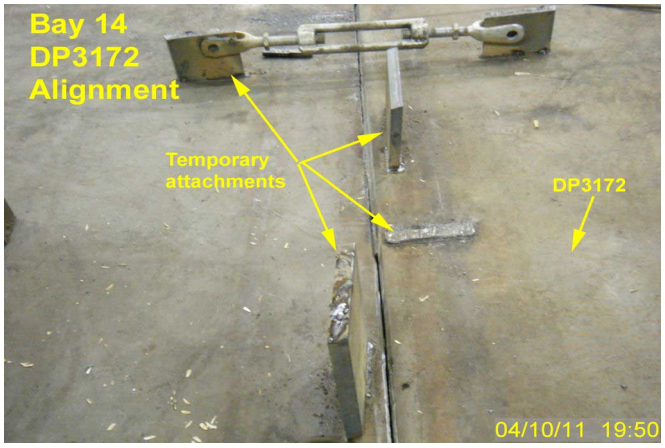
Heat straightening of PCMK TR3002TR2-001-002,004,006,007,008,010,011, under approved Heat Straightening procedure, HSR1 (B)-10279. The in process temperature was observed as 390°C. The ZPMC QC was identified as Wong Xiang Pin. The approved HSR procedure stated that a maximum temperature of 650°C with 1-3 numbers of applications was allowed. The distortion that was previously measured and recorded on the HSR was Maximum 6mm.

Heat straightening of PCMK TR3008TR1-001-002,004,006,007,008,010,011, under approved Heat Straightening procedure, HSR1 (B)-10279. The in process temperature was observed as 470°C. The ZPMC QC was identified as Wong Xiang Pin. The approved HSR procedure stated that a maximum temperature of 650°C with 1-3 numbers of applications was allowed. The distortion that was previously measured and recorded on the HSR was Maximum 6mm.

Heat straightening of PCMK TR3008TR2-001-002,004,006,007,008,010,011, under approved Heat Straightening procedure, HSR1 (B)-10279. The in process temperature was observed as 420°C. The ZPMC QC was identified as Wong Xiang Pin. The approved HSR procedure stated that a maximum temperature of 650°C with 1-3 numbers of applications was allowed. The distortion that was previously measured and recorded on the HSR was Maximum 6mm.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.





Summary of Conversations:

"No relevant conversations."

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 1500026784, who represents the Office of Structural Materials for your project.

Inspected By:	Leavitt,Kelly	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer